

Work Order ID 89461

Thursday, August 23, 2012 11:14:25 AM

\*89461\*

Page 1

Item ID: D350-567-031

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Interior Floor Window (Sliding Door Compatible)

Stop

\*NS2\*

Start Date: 8/23/2012 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 8/23/2012 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: MK

Date: 12-08-23 Tooling:

Date:

Run

Start

\*NR1\*

QC:

Date: SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
N/A	Rev D

100  
**\*100\*** DOCUMENT CONTROL SP 0.00 DAS 16 12/08/24 MK 12/08/23  
DC Memo Photocopy blue file and create labels per PPP D350-567-031 chg001  
Document Control

110  
**\*110\*** Packaging 0.00 12/08/23  
Packaging Memo Pick Packing Kit

\*\*\*ENSURE DT 8439 TEMPLATE IS INCLUDED\*\*\*

120 QC4- 100% Inspect kits for completeness 0.00 DAS 16 12/08/24 Q  
**\*120\*** QC Memo Quality Control

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

**Work Order ID 89461**

Thursday, August 23, 2012 11:14:25 AM

**\*89461\***

Page 2

Item ID: D350-567-031

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Interior Floor Window (Sliding Door Compatible)

Stop

**\*NS2\***Start Date: 8/23/2012 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 8/23/2012 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:		Stop	<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 <b>*130*</b> Packaging	Packaging	0.00	PPP 89459						12/08/24
Packaging	Memo	0.00							
	Identify and pack for shipping as per PPP D350-567-031								
	Location: _____								
	PPP Rev: _____								
140 <b>*140*</b> QC	QC21- Final Inspection - Work Order Release	0.00							12/08/24
Quality Control	Memo	0.00							

ML  
12-08-24  
(2-08-24)

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## **WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: Date:

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS					
			Rework Scrap Use-as-is Work Order Update	Skid-tube Machining Thermoforming Large Fab	Crosstube Small Fab Finishing Composite	Water Jet Prod. Eng. Coor. Rec/Store/Packaging Supplier	Engineering Quality Other				
Part No.: _____											
NCR No. _____											
Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear				General							
Bending	Bend	Grain	Ovalized				Pressure/Forced				
Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance				Temperature/Cure				
Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect				Weld				
Crushed/Crimped.	Burrs	Instructions Incomplete/Unclear	Part Lost/Missing				Wrong Stock Pulled				
Cuffs	Contamination	Maintenance	Part Moved								
Heat Treat	Countersink	Mislabeled	Positioned Wrong								
Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge								
Ripples in Bend	Drill Holes	Offset	Other								
Torque Waves in Extrusion	Drawing	Out of Calibration									
Turning Sequence	Finish	Out of Sequence									
Wave/Twist in Tube	Folio	Outside Dimensions									

# Picklist Print

Thursday, August 23, 2012 11:14:24 AM

Page 1

Work Order ID: 89461

Parent Item: D350-567-031

Parent Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 8/23/2012

Required Date: 8/23/2012

Comments: IPP Rev:A new issue 08-04-25 DD verified by: LL  
IPP Rev:B 08-10-07 as per revD DD verified by:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

**AN526G632R12**

Screw

Purchased

No

120

Each

113.0000

8

8

Location	Loc Qty	Loc Code
----------	---------	----------

ST344 100

122378 100

ST346 12

121556 12

ST347 1

119225 1

**D2463**

Seal

(D2463-0450) CUT (1) AT 45.00" ASPER DWG

\*\*\*PER KIT\*\*\*

17/08/12  
S.7(08/12)

Manufactured

No

120

f

411.7474

3.75

3.75

Location	Loc Qty	Loc Code
----------	---------	----------

ST404 411.74737

72232 15.38

79478 0.43737

83542 395.93

**D3210-1**

Doubler

Manufactured

No

120

Each

6.0000

1

Location	Loc Qty	Loc Code
----------	---------	----------

ST210 6

81497 6

**D3211-1**

Bracket

Manufactured

No

120

Each

9.0000

0

1

12/8/12 SD

Location	Loc Qty	Loc Code
----------	---------	----------

ST211 9

79310 1

81495 8

NCR: Yes / No

DQA: Date:

# WORK ORDER NON-COMPLIANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION			AGAINST DEPARTMENT/PROCESS										
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>									
Part No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>									
NCR No. _____			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>									
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>										
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector							
Doc/Data																
Equip/Tooling																
Operator																
Material																
Setup																
Other																
Process																
Supplier																
Training																
Unapproved																
FAULT CATEGORY																
Landing Gear				General												
Bending	<input type="checkbox"/>			Bend	<input type="checkbox"/>			Grain	<input type="checkbox"/>			Ovalized	<input type="checkbox"/>			Pressure/Forced
Centre Not Concentric to O/S	<input type="checkbox"/>			BOM/Route	<input type="checkbox"/>			Hardware	<input type="checkbox"/>			Over/Under tolerance	<input type="checkbox"/>			Temperature/Cure
Cracks	<input type="checkbox"/>			Broken/Damaged	<input type="checkbox"/>			Inspection Incomplete	<input type="checkbox"/>			Part Incorrect	<input type="checkbox"/>			Weld
Crushed/Crimped.	<input type="checkbox"/>			Burrs	<input type="checkbox"/>			Instructions Incomplete/Unclear	<input type="checkbox"/>			Part Lost/Missing	<input type="checkbox"/>			Wrong Stock Pulled
Cuffs	<input type="checkbox"/>			Contamination	<input type="checkbox"/>			Maintenance	<input type="checkbox"/>			Part Moved	<input type="checkbox"/>			
Heat Treat	<input type="checkbox"/>			Countersink	<input type="checkbox"/>			Mislabeled	<input type="checkbox"/>			Positioned Wrong	<input type="checkbox"/>			
Inspection Strip in Tube	<input type="checkbox"/>			Cut Too Short	<input type="checkbox"/>			Misread	<input type="checkbox"/>			Power Loss/Surge	<input type="checkbox"/>			
Ripples in Bend	<input type="checkbox"/>			Drill Holes	<input type="checkbox"/>			Offset	<input type="checkbox"/>			<input type="checkbox"/>	<input type="checkbox"/>			Other
Torque Waves in Extrusion	<input type="checkbox"/>			Drawing	<input type="checkbox"/>			Out of Calibration	<input type="checkbox"/>				<input type="checkbox"/>			
Turning Sequence	<input type="checkbox"/>			Finish	<input type="checkbox"/>			Out of Sequence	<input type="checkbox"/>				<input type="checkbox"/>			
Wave/Twist in Tube	<input type="checkbox"/>			Folio	<input type="checkbox"/>			Outside Dimensions	<input type="checkbox"/>				<input type="checkbox"/>			

# Picklist Print

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Page 2

Work Order ID: 89461

Parent Item: D350-567-031

Parent Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 8/23/2012

Required Date: 8/23/2012

Start Qty: 1.00

Required Qty: 1.00

D3212-1

Manufactured

No

120

Each

13.0000

1

Floor Window

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST210	13	
79307	6	
81496	7	

D3213-041

Manufactured

No

120

Each

5.0000

1

Door Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST211	5	
81494	5	

DT8439

template

MS20470AD4-5

Rivet, Universal Head

Manufactured

No

120

Each

0.0000

1

MS20470AD4-6

Rivet, Universal Head

Purchased

No

120

Each

2,424.0000

1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

334	1500	
122452	1500	
ST319	924	
118405	349	
120142	575	

MS20470AD4-6

Rivet, Universal Head

Purchased

No

120

Each

3,130.0000

1

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

336	1500	
122452	1500	
ST319	1630	
117395	16	
118927	157	
119109	12	
120142	81	
121524	1364	

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>			
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>			
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Setup										
Other										
Process										
Supplier										
Training										
Unapproved										
FAULT CATEGORY										
Landing Gear				General						
<input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio						
				<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions						
				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge						
				<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled						
				<input type="checkbox"/> Other						

# Picklist Print

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Page 3

Work Order ID: 89461

Parent Item: D350-567-031

Parent Item Name: Interior Floor Window (Sliding Door Compatible)

Start Date: 8/23/2012

Required Date: 8/23/2012

Start Qty: 1.00

Required Qty: 1.00

MS20470AD4-7

Rivet, Universal Head

Purchased

No

120

Each

2,021.0000

20

20

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

336	1300	
-----	------	--

122452	1300	
--------	------	--

ST139	404	
-------	-----	--

121415	404	80
--------	-----	----

ST319	52	
-------	----	--

120769	52	
--------	----	--

ST320	265	
-------	-----	--

116081	117	
--------	-----	--

118614	148	
--------	-----	--

MS21042L064

Nut

Purchased

No

120

Each

559.0000

8

8

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

315	282	
-----	-----	--

122441	282	
--------	-----	--

ST300	77	
-------	----	--

121556	77	8
--------	----	---

ST317	200	
-------	-----	--

122151	200	
--------	-----	--

NAS1149DN632J

Washer

Purchased

No

120

Each

306.0000

8

8

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

298	200	
-----	-----	--

122441	200	
--------	-----	--

ST298	106	
-------	-----	--

118428	106	8
--------	-----	---

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS								
			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>						
			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>						
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>						
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>							
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector				
Doc/Data													
Equip/Tooling													
Operator													
Material													
Setup													
Other													
Process													
Supplier													
Training													
Unapproved													
FAULT CATEGORY													
<b>Landing Gear</b> <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>General</b> <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio		<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions				<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled	

## 5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	1	1				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
				1	1	D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -2031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
				11		
1				11	D2125	REPLACEMENT WINDOW, SMALL
	1			11	D2942	REPLACEMENT WINDOW, LARGE
		1		11	D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1				11	D2126-0600	SEAL
	1			11	D2463-0750	NEOPRENE SEAL
		1		11	D2463-0860	NEOPRENE SEAL
9	12			11	2600-6	1/4 TURN FASTENER
9	12			11	2600-LW	WASHER
9	12			11	212-12	RECEPTACLE
22	21			11	AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
44	42			11	AN960JD8	WASHER
22	21			11	MS21042L08	NUT (OR MS21042-08)
18	24			11	MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD		V	N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	-D3213-041	DOOR ASSEMBLY
				1	D3293-1	DOUBLER
				1	D3294-1	BRACKET
				1	D3295-041	FLOOR WINDOW
				1	D3296-041	DOOR ASSEMBLY
				1	D2463-0530	NEOPRENE SEAL
				9	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
				9	AN960JD6	WASHER
				9	MS21042L06	NUT (OR MS21042-06)
				2	MS20470AD4-5	RIVET
				115	MS20470AD4-6	RIVET
				15	MS20470AD4-7	RIVET

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Revision: D  
Date: 08.07.08